

46

DART AEROSPACE LTD	Work Order:	21874
Description: Doubler	Part Number:	D3302-7
Dwg: D3302 Rev. A	Qty:	10
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	Hy	04.11.09	10
2	MV	Cut blank: 2.100" x 2.100" Material: 5052-H32 or 6061-T6(QQ-A-250/8 or QQ-A-250/11) 0.040" thick (M5052H32S.040 or M6061T6S.040) Identify for D3302-7 Batch: <u>M15982</u>	BE	07.11.08	10
3	MV	Machine as per Folio FA453 and Dwg D3302 Identify as D3302-7	BE	07.11.08	10
4	QC2	Inspect parts as they come off the CNC machine	BE	07.11.08	10
5	QC8	Second check	ED	07.11.08	10
6	GA	Deburr break all unmarked sharp edges 0.005 to 0.010	ml	04-11-17	10
7	QC5	Inspect work to Step 6	IB	04.11.18	10
8	FP	Chemical Conversion Coat as per QSI 005 4.1	MM	04/11/22	10
9	QC3	Inspect Chemical Conversion Coat	PD	04-11-22	10
10	ST	Identify and Stock	CL	04/11/22	10
11	AC	Cost / part <u>4.04</u>	SAC	04-11-23	10
12	DC	Close W/O <u>4.04</u> Inspect Level 21	Hy	04.11.24	10

Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED
[Signature] 07-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

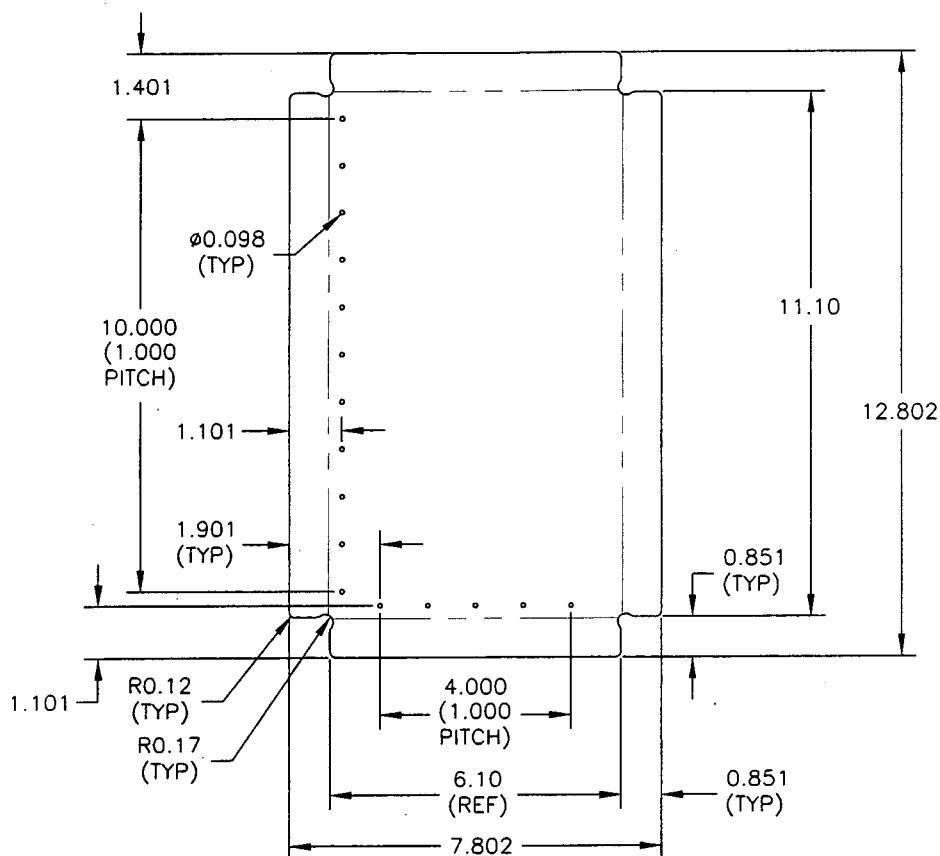
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

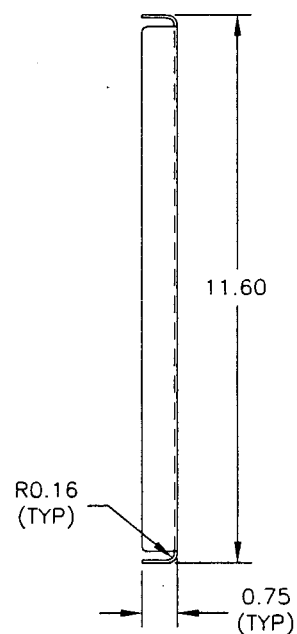
QA: N/C Closed: _____ Date: _____



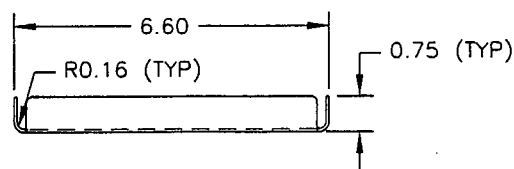
DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3302	REV. A SHEET 1 OF 4
DATE 04.07.06		TITLE DOUBLER	SCALE 1:4
A	04.07.06	NEW ISSUE	



D3302-1 FLAT PATTERN



**D3302-1 DOUBLER
BEND DETAIL**



D3302-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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04.09.04
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ENGINEERING

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NOTICE**

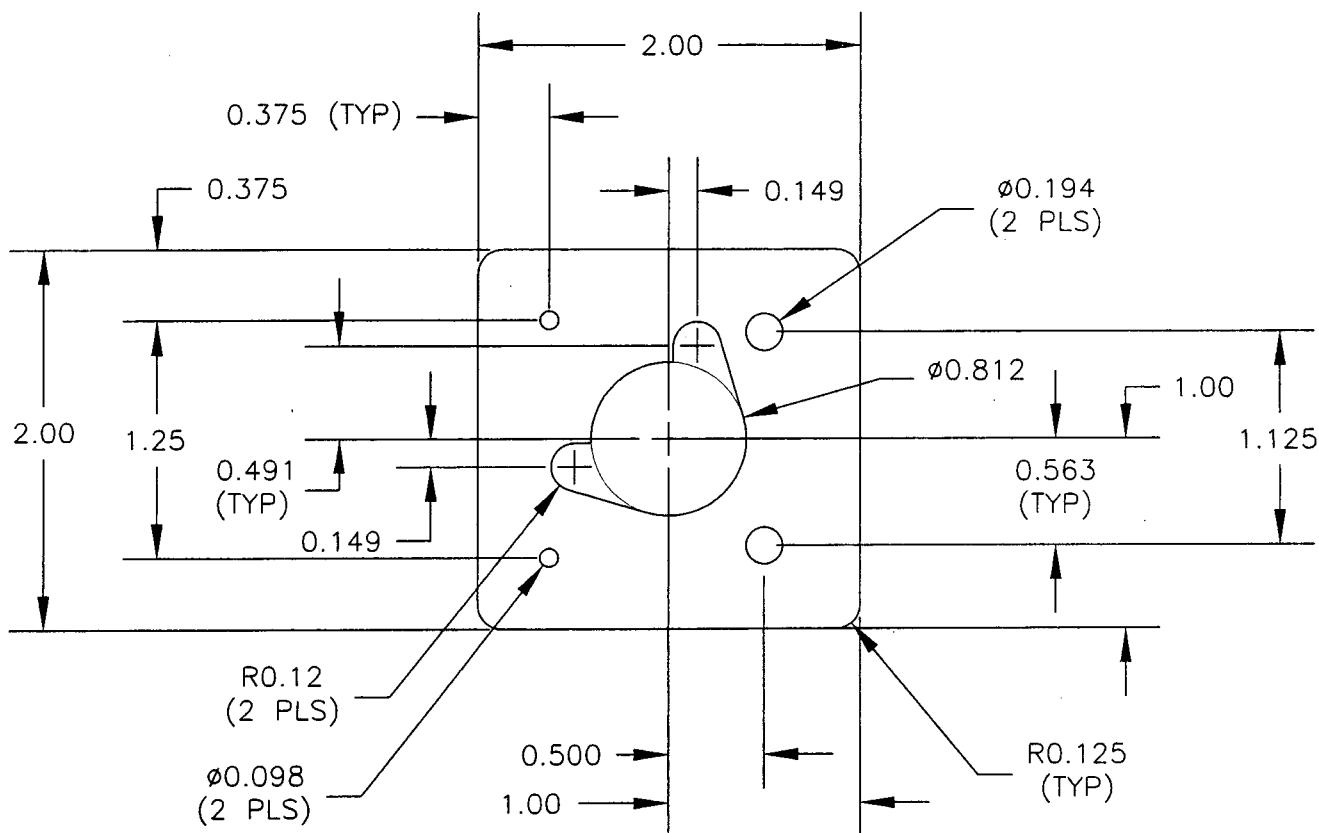
**WORK ORDER
NO. 21874**

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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3302	REV. A SHEET 4 OF 4
DATE 04.07.06		TITLE DOUBLER	SCALE 1:1
A	04.07.06	NEW ISSUE	



D3302-7

RELEASED
04.07.06

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ENGINEERING

D3302-7 NOTES:

- 1) MATERIAL: 5052-H32 OR 6061-T6 (QQ-A-250/8 OR QQ-A-250/11)
0.040 THICK (REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
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REVISION
NOTICE

ORDER

21874

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 09, 2004
03:10 pm

Work Order No : 0021874
Project Name : D3302-7
Project For : WK446
Work Order Type : Main
Main WO Number :
House Part Number : D3302-7
Description : Doubler
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 11-09-04
Est Finish Date : 11-18-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			


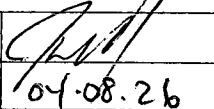

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	03302-7
Inspection Dwg:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

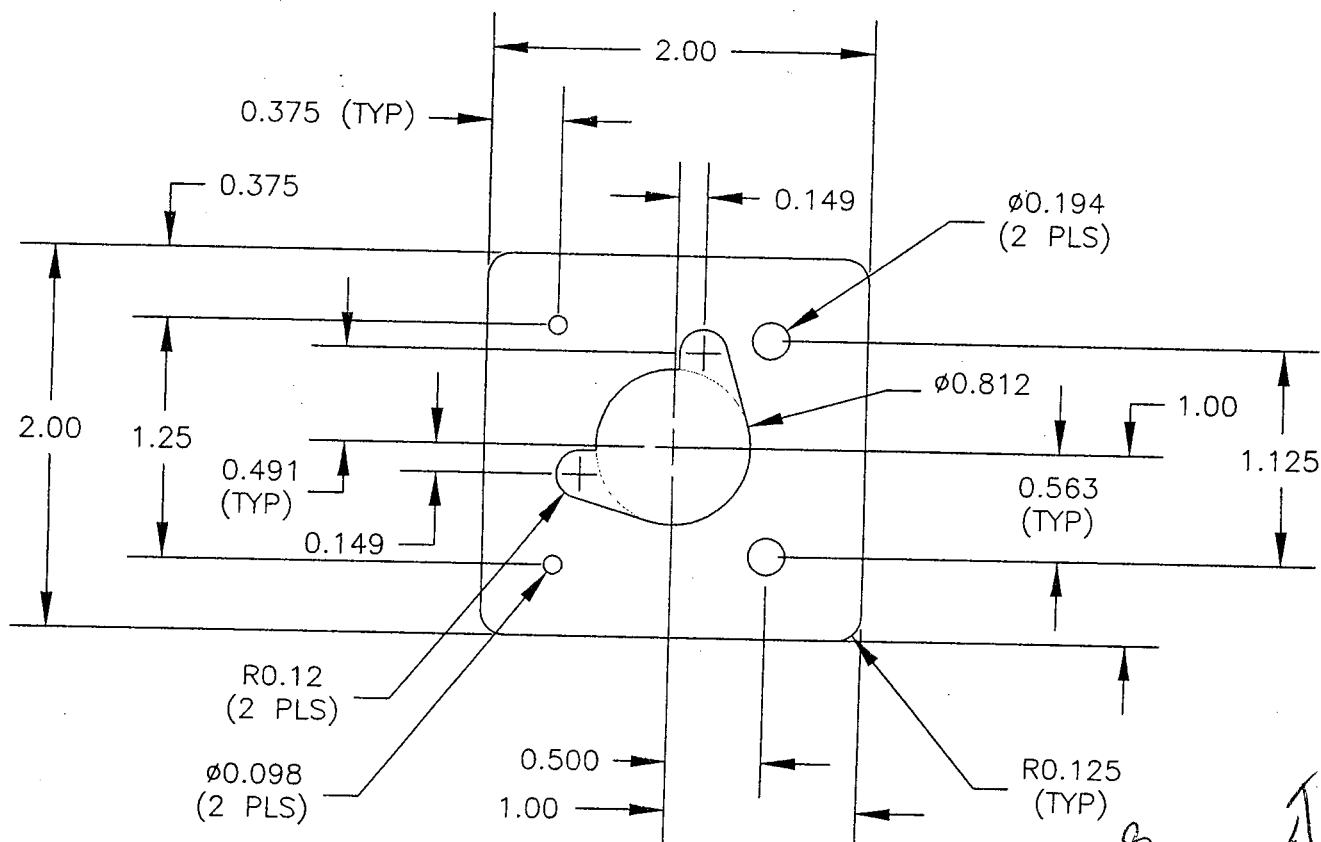
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	± 0.03	2.001	✓			
0.149	± 0.01					
$\phi .194$	$\begin{matrix} +0.005 \\ -0.000 \end{matrix}$	$\phi .194$	✓			
$\phi .812$	"	$\phi .812$	✓			
1.00	± 0.03	0.997	✓			
0.563	± 0.01					
1.125	"	1.122	✓			
R.125	"	R.125	✓			
1.00	± 0.03	0.994	✓			
0.500	± 0.01					
$\phi .098$	$\begin{matrix} +0.005 \\ -0.000 \end{matrix}$	$\phi .099$	✓			
R.120	± 0.01	R.125	✓			
0.149	"					
0.149	"					
1.25	± 0.03	1.247	✓			
2.00	"	2.001	✓			
0.375	± 0.01	0.379	✓			
0.375	"	0.377	✓			
0.040	"	0.036	✓			

Measured by: 	Audited by: 	Prototype Approval: 
Date: 04.08.26	Date: 04.08.26	Date: 04.08.26

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3302	REV. A SHEET 4 OF 4
DATE 04.07.06		TITLE DOUBLER	SCALE 1:1
A	04.07.06	NEW ISSUE	

1504-6041



D3302-7

*Blank
2.100 x 2.100*

*la 453
IPP, Insp sheet
Prog DONE
DT 8563*

D3302-7 NOTES:

- 1) MATERIAL: 5052-H32 OR 6061-T6 (QQ-A-250/8 OR QQ-A-250/11)
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